

Work Order ID 136897

Wednesday, September 16, 2015 3:34:52 PM

136897

Page 1

Item ID: D3230-041 Accept ***N19000040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Basket Wedge Assembly
 Start Date: 9/17/15 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 10/02/15 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: SH Date: 9 15 09 16 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3230	D								

110 0.00 **DAS**
110 Large Fab **43**
 Large Fab Memo 0.00 **9-89** **SEP 22 2015**
 Large Fab

- 1-Cut 3/4 x 3/4 square tubing as per Dwg D3230
- 2- Drill and c'sink holes
- 3- Cut mesh as per dwg
- 4 -Deburr & Remove all Markings From Material
- 5-Weld bushings and fabricate basket wedge assembly as per D3230
- 6- USE DT10137 TO LOCATE BACK HINGE AS PER DWG.
- ***LOOK AT DWG FRONT MESH MUST BE WELDED INSIDE***

A/R SS ROD Batch: 4131414

Ship Out 7/15

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
								Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	

Root Cause				FAULT CATEGORY							
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence	☐
Past Expiry Date	☐	Manufacturing Process	☐	OTHER :							
Misidentified	☐	Past Due	☐								

Wednesday, September 16, 2015 3:34:52 PM

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Page 2

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 9/17/15 **Start Qty:** 1.00 ***1***

Cust Item ID:

Required Date: 10/02/15 **Req'd Qty:** 1.00 ***1***

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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120

QC9- Inspect visual per QSI004- Fusion Welds

0.00

120

QC

Memo

0.00

Quality Control

1 AUG 06 2015 DAS
24
9-89

130

QC5- Inspect part completeness to step on W/O

0.00

130

QC

Memo

0.00

Quality Control

1 AUG 06 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐		Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐					
		OTHER : _____							

Work Order ID 136897***136897***

Page 3

Item ID: D3230-041

Accept

N1900040100Setup Start ***NS1***

Revision ID:

Item Name: Basket Wedge Assembly

Stop ***NS2***Start Date: 9/17/15 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 10/02/15 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
140	<i>M 132709</i>								
Powdercoat	Memo	0.00							
Powder Coating	1ST COAT: <i>1:30</i> START TIME: <i>1:30</i> OVEN TEMPERATURE: <i>400°</i> FINISH TIME: <i>2:00</i> **** if necessary***** 2ND COAT: START TIME: _____ OVEN TEMPERATURE: _____ FINISH TIME: _____								
150	QC3- Inspect Part Finish	0.00							
150									
QC	Memo	0.00							
Quality Control									

*1 15-10-6 233**(1)* **DAS 38 9-89**
OCT 07 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
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Misidentified ☐	Past Due ☐																																																																

136897

Page 4

N900040100

Setup Start *NS1*

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Start Date: 9/17/15 **Start Qty:** 1.00 ***1***

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Customer:

Reference:

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 QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop** ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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180

180

Packaging

Packaging

Identify as per dwg & Stock Location:

Packaging

Memo

0.00

0.00

0.00

0.00

OCT 07 2015

DA
33

190

190

QC

Quality Control

QC21- Final Inspection - Work Order Release

Memo

OCT 6 7 2515

MF
15-10-05

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube ☐</td> <td style="width:15%;">Cross tube ☐</td> <td style="width:15%;">Water Jet ☐</td> <td style="width:15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																							
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OTHER : ☐																																																															

Picklist Print

Wednesday, September 16, 2015 3:34:58 PM

Page 1

Work Order ID: 136897

136897

Parent Item: D3230-041

D3230-041

Parent Item Name: Basket Wedge Assembly

Start Date: 9/17/15

Required Date: 10/02/15

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:D 09-02-25 rev.c as per dwg DD verified by:EC IPP Rev:E
15.04.14 revD as per dwg DD verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2232-3		Manufactured	No			110	Each	26.0000	2	2	DAS 43 9-89	SEP 17 2015	
✓ *D2232-3*									**				
Basket Hinge													

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
WA004	26	
115847	20	
132731	6	

~~B135756~~ →
B132731 → 2

D2327-3		Manufactured	No			110	Each	9.0000	2	2	DAS 43 9-89	SEP 17 2015	
✓ *D2327-3*									**				
Spacer Bushing													

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
WA004	9	
131972	9	

B131972 → 2

D3759-1		Manufactured	No			110	Each	24.0000	5	5	DAS 43 9-89	SEP 17 2015	
✓ *D3759-1*									**				
Bushing													

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
WA004	24	
135756	24	

B135756 → 5

D4021-9		Manufactured	No			110	Each	36.0000	4	4	DAS 43 9-89	SEP 17 2015	
✓ *D4021-9*									**				
Bushing													

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
WA004	36	
120334	2	
122601	4	
134919	30	

B134919 → 4

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
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Root Cause				FAULT CATEGORY							
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions	☐
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Picklist Print

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Page 2

Work Order ID: 136897

136897

Parent Item: D3230-041

D3230-041

Parent Item Name: Basket Wedge Assembly

Start Date: 9/17/15

Required Date: 10/02/15

Start Qty: 1.00

Required Qty: 1.00

M304EX0.75-16F

Purchased

No

110

sf

408.9522

5.15

5.421053

DAS

43

9-89

SEP 17 2015

M304EX0 75-16F

Expanded Metal Flat SS

**

1132745

Location

Loc Qty

Loc Code

WA004

408.9522

M132745

208.8922

M132864

40.06

M132967

160

M304TS0.750W.065

Purchased

No

110

f

881.3500

26

27.36842

DAS

43

9-89

SEP 17 2015

M304TS0 750W 065

304 SQ Tube .75x.75x.065W

**

1132270 → 27.36
EPD MAT Scrap + 3

Location

Loc Qty

Loc Code

WA004

881.35

125513

14

m128495

95.35

m132190

30

m132270

142

m132924

600

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

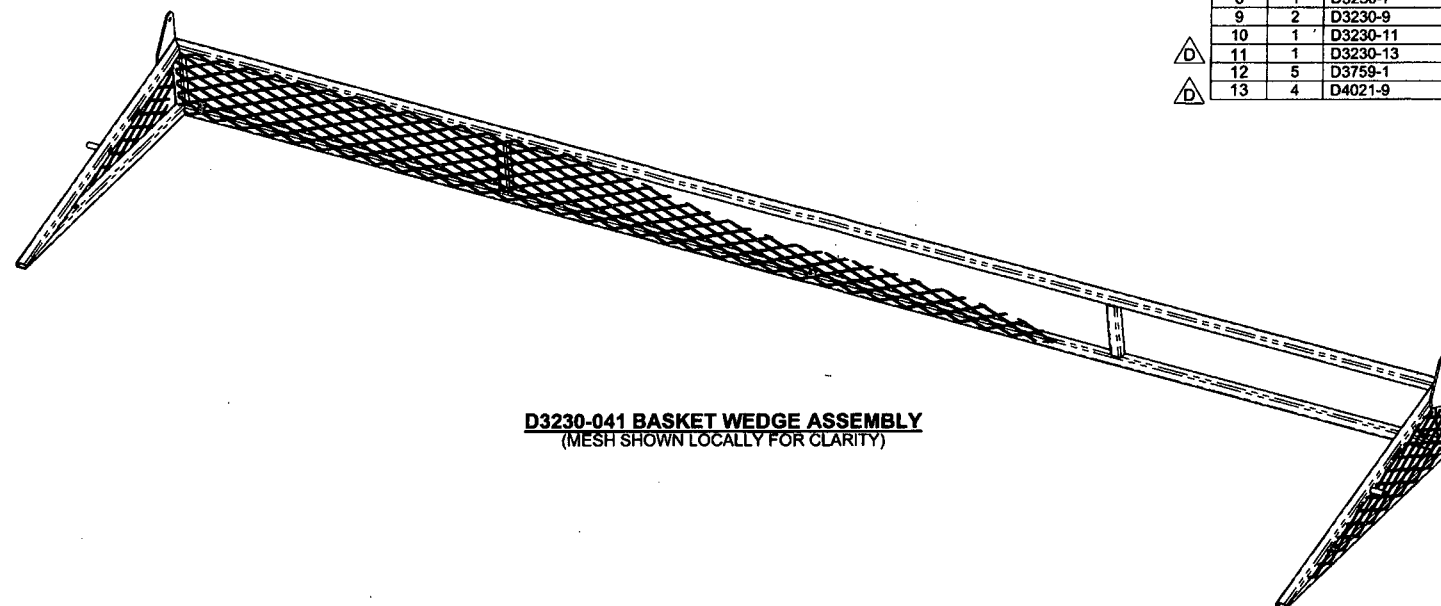
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OTHER : ☐																																																															

8 7 6 5 4 3 2 1

ITEM	QTY	P/N	DESCRIPTION
	X	D3230-041	BASKET WEDGE ASSEMBLY
1	2	D2232-3	HINGE PLATE
2	2	D2327-3	SPACER BUSHING
3	1	D3230-1	RIB
4	1	D3230-2	RIB
5	1	D3230-3	RIB
6	1	D3230-4	RIB
7	4	D3230-5	RIB
8	1	D3230-7	RIB
9	2	D3230-9	SIDE MESH
10	1	D3230-11	FRONT MESH
11	1	D3230-13	RIB
12	5	D3759-1	BUSHING
13	4	D4021-9	BUSHING



D3230-041 BASKET WEDGE ASSEMBLY
(MESH SHOWN LOCALLY FOR CLARITY)

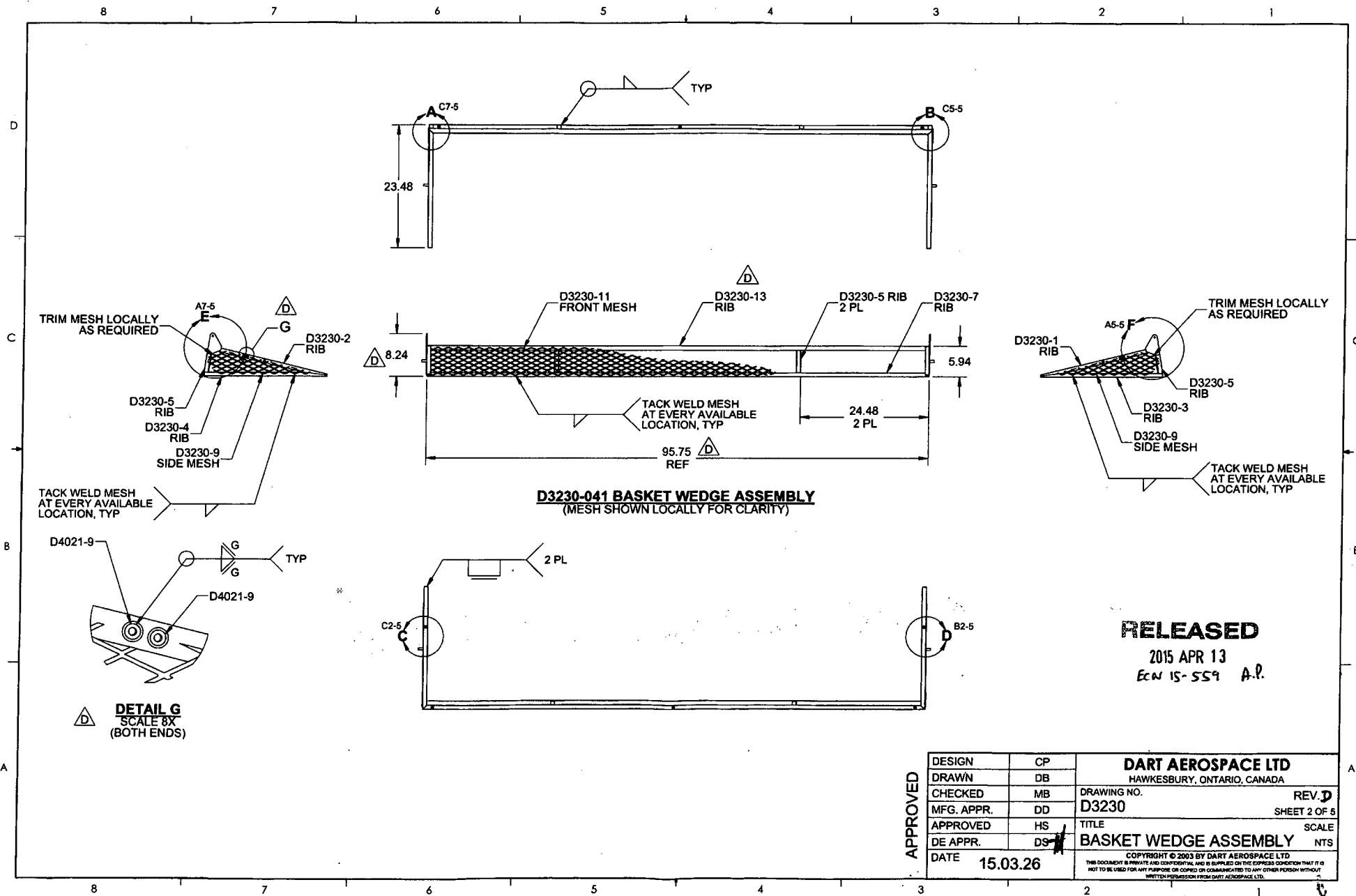
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2015 APR 13
ECN 15-559 A.P.

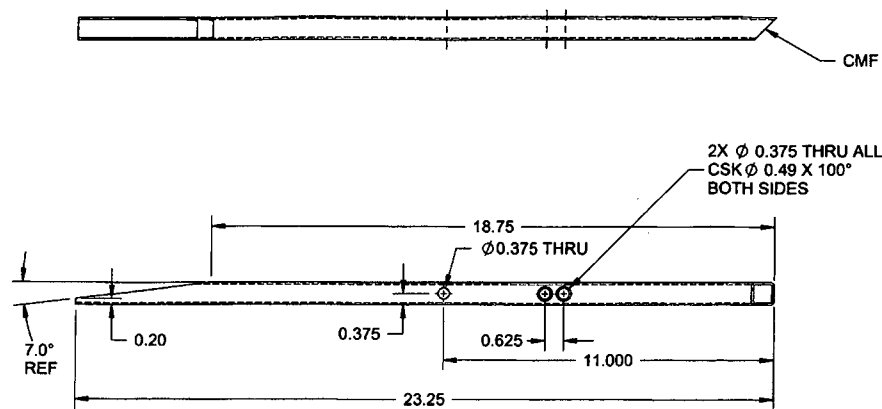
20150916 SW 136897

D	CHANGE OVERALL LENGTH TO 95.75 (WAS 96.00) TO IMPROVE FIT ON BASKET (REF NCR15-4557), ADD DETAIL G (SH 2), ADD D3230-13, D4021-9 (4 PL)	DB	15.03.26
C	REDESIGN (SEE NCR 09-010); REFORMAT DRAWING TO CURRENT STANDARDS	MB	09.01.27
B	15.75 WAS 16.00; REMOVE D2581; ADD VIEW B-B; D2327-3 ADDED	CB	06.11.10
A	NEW ISSUE	CP	03.10.31
REV.	DESCRIPTION	BY	DATE
DESIGN	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DB		
CHECKED	MB	DRAWING NO.	REV. D
MFG. APPR.	DD	D3230	SHEET 1 OF 5
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	BASKET WEDGE ASSEMBLY	NTS
DATE	15.03.26	COPYRIGHT © 2003 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

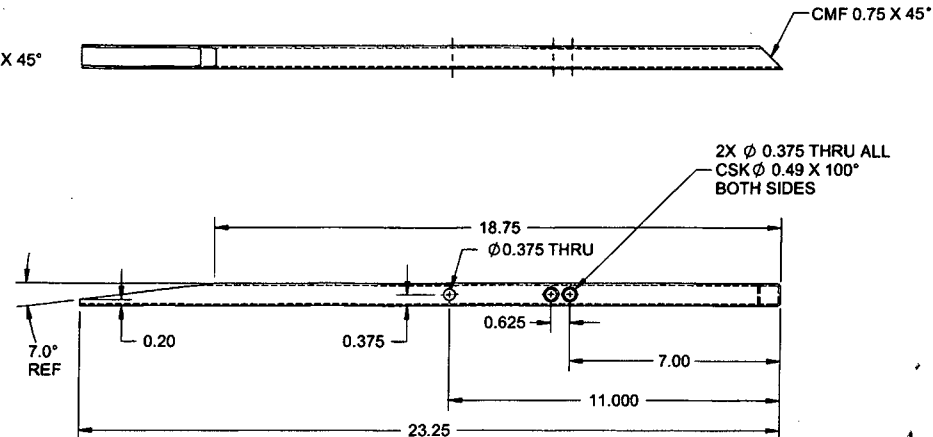
- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY PER DART QSI 044 6.1
 - 7) WEIGHT: 19.8 lbs
 - 8) WELDING: PER DART QSI 004

8 7 6 5 4 3 2 1

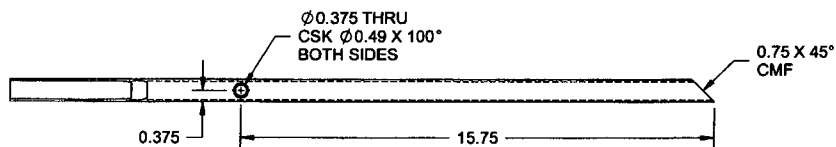




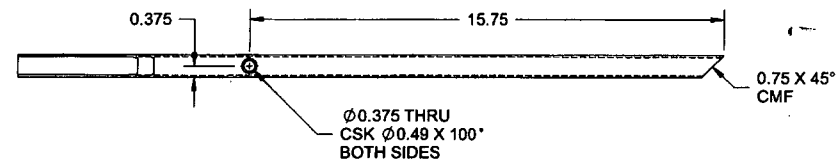
D3230-1 RIB



D3230-2 RIB



D3230-3 RIB

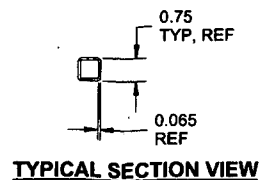


D3230-4 RIB

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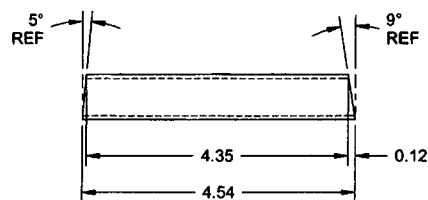
2015 APR 13
ECN 15-559 A.P.

- NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL REF. DART SPEC. M304TS0.750W0.065
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.99 lbs EACH

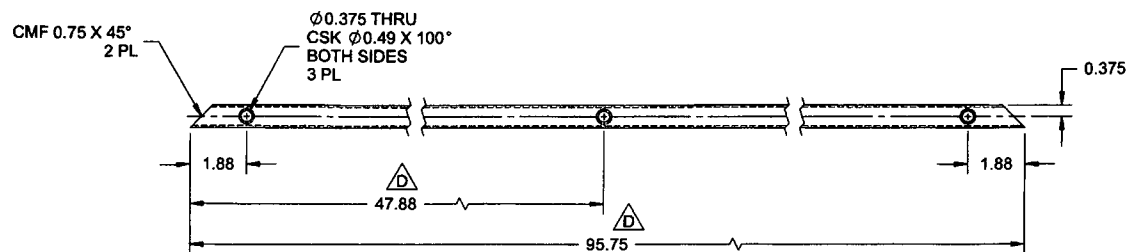


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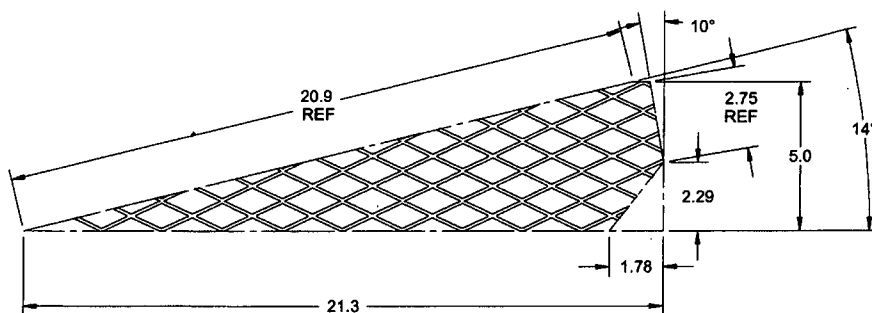
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DRAWN	DB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	MB	DRAWING NO.	REV. D
MFG. APPR.	DD	D3230	SHEET 3 OF 5
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	BASKET WEDGE ASSEMBLY	NTS
DATE	15.03.26	COPYRIGHT © 2003 BY DART AEROSPACE LTD	
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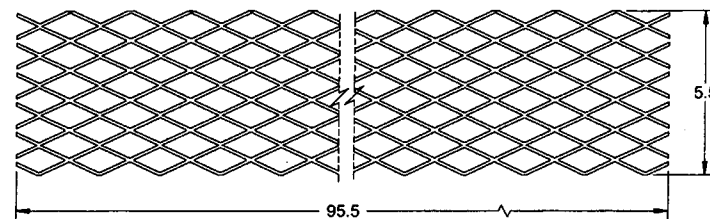
D3230-5 RIB



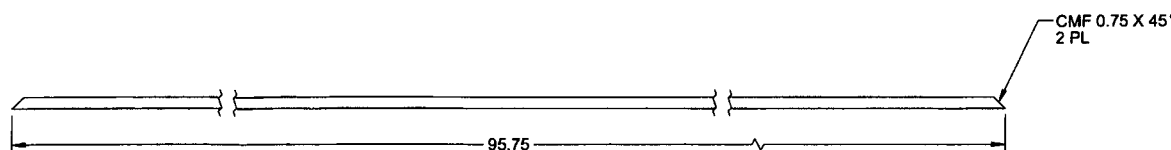
D3230-7 RIB



D3230-9 SIDE MESH



D3230-11 FRONT MESH



D3230-13 RIB

NOTES:

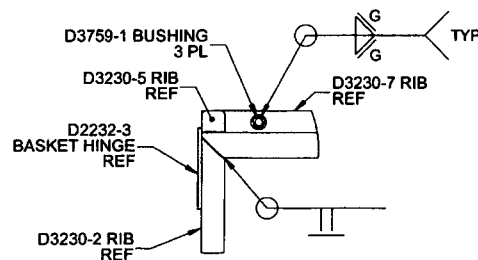
- 1) MATERIAL:
D3230-5/-7/-13: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL
REF. DART SPEC. M304TS0.750W0.065
D3230-9/-11: 3/4-16F EXPANDED STAINLESS STEEL
REF. DART SPEC. M304EX0.75-16F
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D3230-5 = 0.21 lbs; D3230-7 = 4.55 lbs
D3230-9 = 0.20 lbs; D3230-11 = 1.94 lbs; D3230-13 = 4.56 lbs

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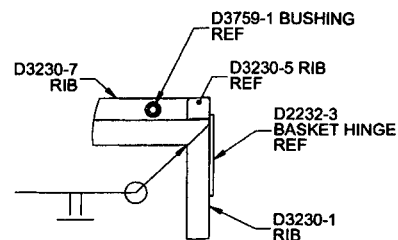
2015 APR 13
ECN 15-559 A.R.

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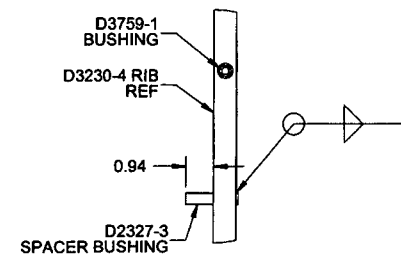
DESIGN	CP	DART AEROSPACE LTD	
DRAWN	DB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	MB	DRAWING NO.	REV. D
MFG. APPR.	DD	D3230	SHEET 4 OF 5
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	BASKET WEDGE ASSEMBLY	NTS
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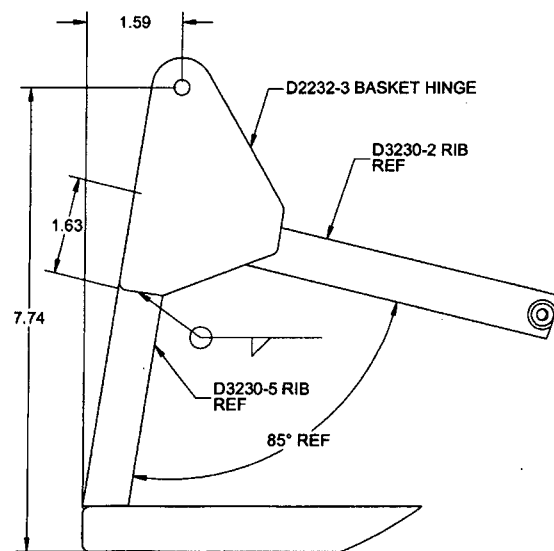
DETAIL A D6-2
MESH NOT SHOWN FOR CLARITY
SCALE 4X



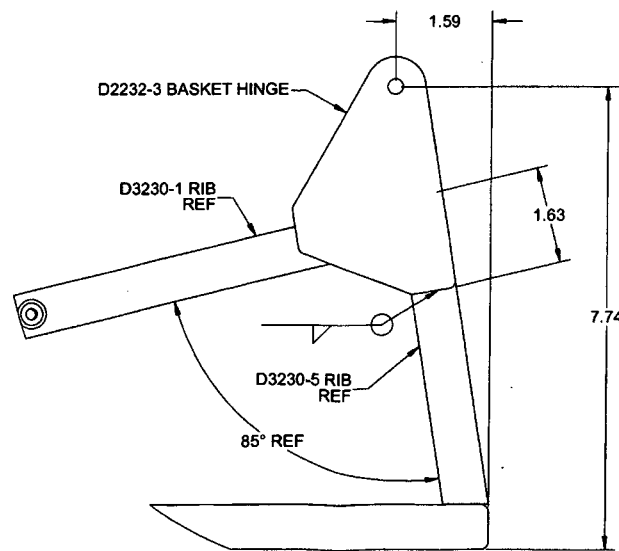
DETAIL B D3-2
MESH NOT SHOWN FOR CLARITY
SCALE 4X



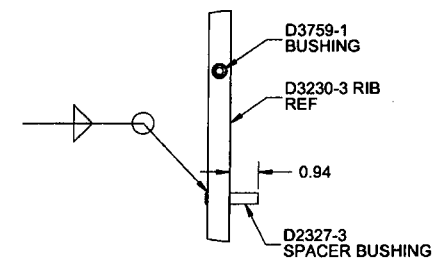
DETAIL C
MESH NOT SHOWN FOR CLARITY
SCALE 4X B6-2



DETAIL E C7-2
MESH NOT SHOWN FOR CLARITY
SCALE 8X



DETAIL F C2-2
MESH NOT SHOWN FOR CLARITY
SCALE 8X



DETAIL D B3-2
MESH NOT SHOWN FOR CLARITY
SCALE 4X

RELEASED

2015 APR 13

ECN 15-559 A.P.

DESIGN	CP	DART AEROSPACE LTD	
DRAWN	DB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	MB	DRAWING NO.	REV. D
MFG. APPR.	DD	D3230	SHEET 5 OF 5
APPROVED	HS	TITLE	SCALE
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